

SUB

32.

A method of forming a fuel container with an opening and a cap sealing the opening, comprising the steps of:

providing a pair of mold halves defining a first mold cavity to form and define the shape of a container and adjacent the first cavity a second cavity to form at least one cap in a flash section;

providing a parison with at least one hydrocarbon fuel vapor barrier layer of a polymeric material disposed between inner and outer layers of a different polymeric material which is heat weldable;

closing the mold halves together to receive and compress two overlapping portions of the parison between them forming at least one flash section in the region of the second cavity and at least one cap in the flash section with the cap having twice as many vapor barrier layers as the vapor barrier layer(s) of the container;

providing a pressurizing fluid into the parison within the closed mold halves to expand the parison within the first mold cavity to form the entire container and define the shape of the container;

C after blow molding forming an opening through the container at a location spaced from the cap;

separating the cap from the flash section;

disposing the cap over the opening; and

heat welding the cap to the container circumferentially continuously to permanently attach and seal the cap to the container to permanently close, seal and provide a fuel vapor barrier for the opening.

33.

The method of claim 32 which also comprises heat welding at least one of the inner layer and the outer layer of the cap to the outer layer of the container to permanently attach and seal the cap to the container.

34.

The method of claim 32 which further comprises simultaneously extruding the at least one fuel vapor layer and the inner and outer layers into the parison which is received in a generally molten state between the open mold in a blow molding machine to form the container and cap.

35.

a. The method of claim 32 wherein the inner layer and the outer layer of the parison, container and cap are of a high density polyethylene polymer material.

36.

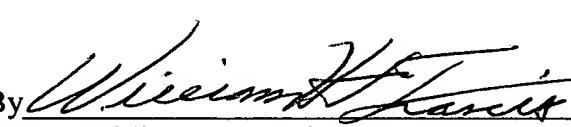
The method of claim 35 wherein the layers of high density polyethylene polymer material of the container and the cap are heat welded together to permanently attach and seal the cap to the container.

Respectfully submitted

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WHF:sjw

Enclosures

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